

Work Order ID 86144

June-21-12 8:39:10 AM

86144

Page 1

Item ID: D4022-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Fuel Transfer Pump Assembly

Stop

NS2

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4022 C

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4022

Metal set A4 batch: M116143

O-ring Lub as per dwg batch: M118348

6 φ FF
12-07-17

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.00

166337 166338

166336 166325

166327 166326

DAS
16
0.00 07/07/12

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fuel Transfer Pump Assembly

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location: 146

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

62

12/7/18

12/7/18

MF
12-07-18

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June-21-12 8:39:13 AM

Page

86144

D4022-041

Required Date: 05/07/2012

Required Qty: 4.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC IPP REV:C 11.11.22
PER ECN11-665 DD VEF:EC IPP REV:D 12.02.08 replace
AN818-6D for AN815-6D DD VEF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4022-1 *D4022-1* Fuel Transfer Pump		Manufactured	No		80086	100	Each	0.0000	1	4	6	FF 12-07-17	
D4022-5 *D4022-5* Thermal Switch		Manufactured	No			100	Each	29.0000	1	4	6	FF 12-07-17	
					<u>Location</u>								
					ST083			29					
					79949			29					
AN815-6D *AN815-6D* Union-M-Flare		Purchased	No			100	Each	30.0000	2	8	6	FF 12-07-17	
					<u>Location</u>								
					ST325			30					
					119396			6					
					119433			2					
					122087			22					
MS29512-06 *MS29512-06* O-RING		Purchased	No			100	Each	4.0000	2	8	12	FF 12-07-17	
					<u>Location</u>								
					ST293			4					
					121166			4					

W/O:		WORK ORDER CHANGES					
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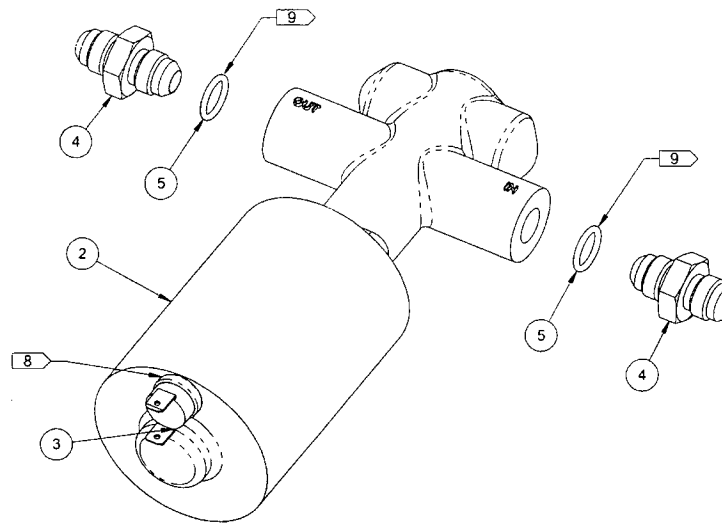
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4022-041	FUEL TRANSFER PUMP ASSEMBLY	A8150-B1-JCA
2	1	D4022-1	FUEL TRANSFER PUMP	
3	1	D4022-5	THERMAL SWITCH	
4	2	AN815-6D	FITTING, UNION	
5	2	MS29512-06	O RING	



D4022-041 FUEL TRANSFER PUMP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20144 MLC
12/08/21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.61 lbs
- 8) ATTACH D4022-5 THERMAL SWITCH TO D4022-1 FUEL PUMP IN LOCATION SHOWN USING METALSET A4
- 9) LUBRICATE O-RING WITH ULTRACHEM ASSEMBLY FLUID #1, FUEL-LUBE, MOLYKOTE 55 O-RING GREASE OR EQUIVALENT

C	CORRECTED TYPO: AN815-6D WAS AN818-6D, ZN D7-1. CORRECTED SPELLING OF "AEROSPARES", ZN B5-3.	DC	12.02.09
B	CORRECTED SPELLING OF "AEROSPARES", ZN B5-3. REF CAR 11-50.	DC	11.09.28
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JS</i>		
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.		D4022	SHEET 1 OF 4
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	FUEL PUMP	NTS
DATE	12.02.09	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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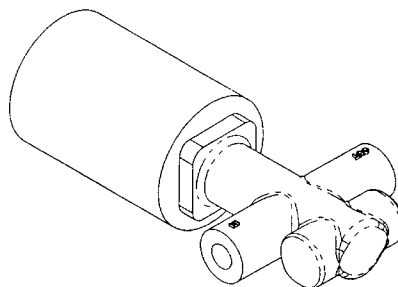
NOTE: Date & initial all entries

DART AEROSPACE
PART NUMBER

D4022-1

JOHN CAMERON AVIATION
PART NUMBER

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING

DART PART NUMBER	SUPPLIER	SUPPLIER PART NUMBER	OPERATING VOLTAGE	FLOW (GPH)	OUTPUT PRESSURE (PSI)	TEMPERATURE RANGE
D4022-1	WELDON	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F
	AEROSPARES ACCESSORIES	A8150-B1	24 VDC	35 - 50	5 - 25	-65°F TO +185°F

D4022-X FUEL TRANSFER PUMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.6 lbs

DESIGN	<i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>SC</i>	
CHECKED	<i>SC</i>	DRAWING NO. D4022
MFG. APPR.		REV. C SHEET 2 OF 4
APPROVED	<i>SC</i>	TITLE FUEL PUMP
DE APPR.	<i>SC</i>	SCALE NTS
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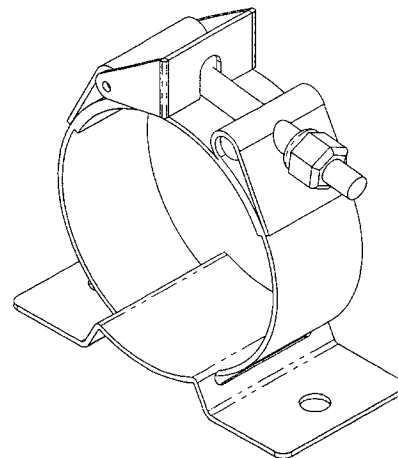
DART AEROSPACE
PART NUMBER

JOHN CAMERON AVIATION
PART NUMBER

D4022-3

REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING



86144

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS MOTOR SIZE (ϕ)
D4022-3	WELDON	TC 250-100	STAINLESS STEEL	2.5
	AIRCRAFT SPRUCE AND SPECIALTY	05-00021	STAINLESS STEEL	2.5
	AEROSPARES ACCESSORIES	TC 250-100	STAINLESS STEEL	2.5



D4022-X FUEL PUMP MOUNTING BRACKET

2012-03-02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. C
MFG. APPR.		D4022	SHEET 3 OF 4
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	FUEL PUMP	NTS
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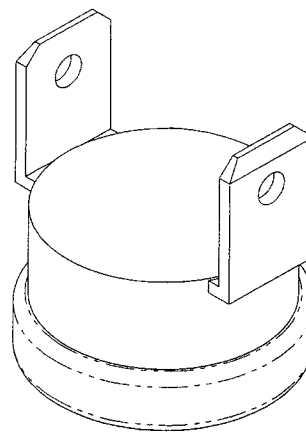
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4022-5	REF JCA/M47/D3/SHT 13

SPECIFICATION CONTROL DRAWING

86144



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	ALTERNATE PART NUMBER	TEMPERATURE WHEN SWITCH OPENS
D4022-5	FARNELL	1006847	3775628	125°F
	HONEST-WELL	T23A125BSR2-15	3775628	125°F
	NEWARK	98K1992	3775628	125°F

D4022-X THERMAL SWITCH

12135
2012-03-02
ANT

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) BREAK SHARP EDGES: N/A

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN	DRAWING NO. D4022
DRAWN	REV. C
CHECKED	SHEET 4 OF 4
MFG. APPR.	TITLE
APPROVED	SCALE
DE APPR.	NTS
DATE 12.02.09	FUEL PUMP
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